

Date: Monday, 5/1/2006 1:49:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L BASKET BASE
Job Number : 26877A	
Estimate Number : 11273	
P.O. Number : N/A	Part Number : D2252041
This Issue : 5/1/2006 S.O. No. : N/A	Drawing Number : UNDER REVIEW → 060502
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : E
Previous Run : 25445A	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 5/20/2006
Checked & Approved By : <u>06.05.01</u>	Qty: 1 Um: Each
Comment : Est Rev: Revised as per Rev E 05-12-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31661	Basket Hoop
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Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
5	D3166-1	Hoop	B26217

06/05/01

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: M100748

06/05/01

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 5 D2235-1 From D3166-1

2- Cut Ribs as per Dwg D2252

3-Drill hole in D2252-1as per Dwg D2252

4-Deburr & Remove all Markings from Material

06/05/01

4.0	D22531	Lug
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2253-1	Gusset	B12413

06/05/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 26877A

Part Number: D2252041

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Seq. #:	Machine Or Operation:	Description :
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5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Bushing	B25823

AA 06/05/01

6.0	D2581	Mounting Bracket
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2581	Mounting Chancel	B26204

AA 06/05/01

7.0	D2254	Gusset for D206bskt
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2254	Lug	B23421

AA 06/05/01

8.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	HINGE	B25239

AA 06/05/01

9.0	M304EX07516F	Expanded Metal Flat Stai
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Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
32 sf	M304EX0.75-16F	Expanded Metal	M100722

AA 06/05/01

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required

A/R SS ROD Batch: M100322

AA 06/05/01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 02/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 26877A

Part Number: D2252041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

06-05-08 (1)

12.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/05/08 (1)

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-09 (1)

14.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

15.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/11 (1)

Job Completion



U 06-05-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED #	APPROVED #	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206L)	SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

E

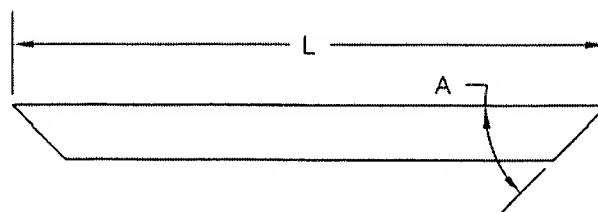
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E

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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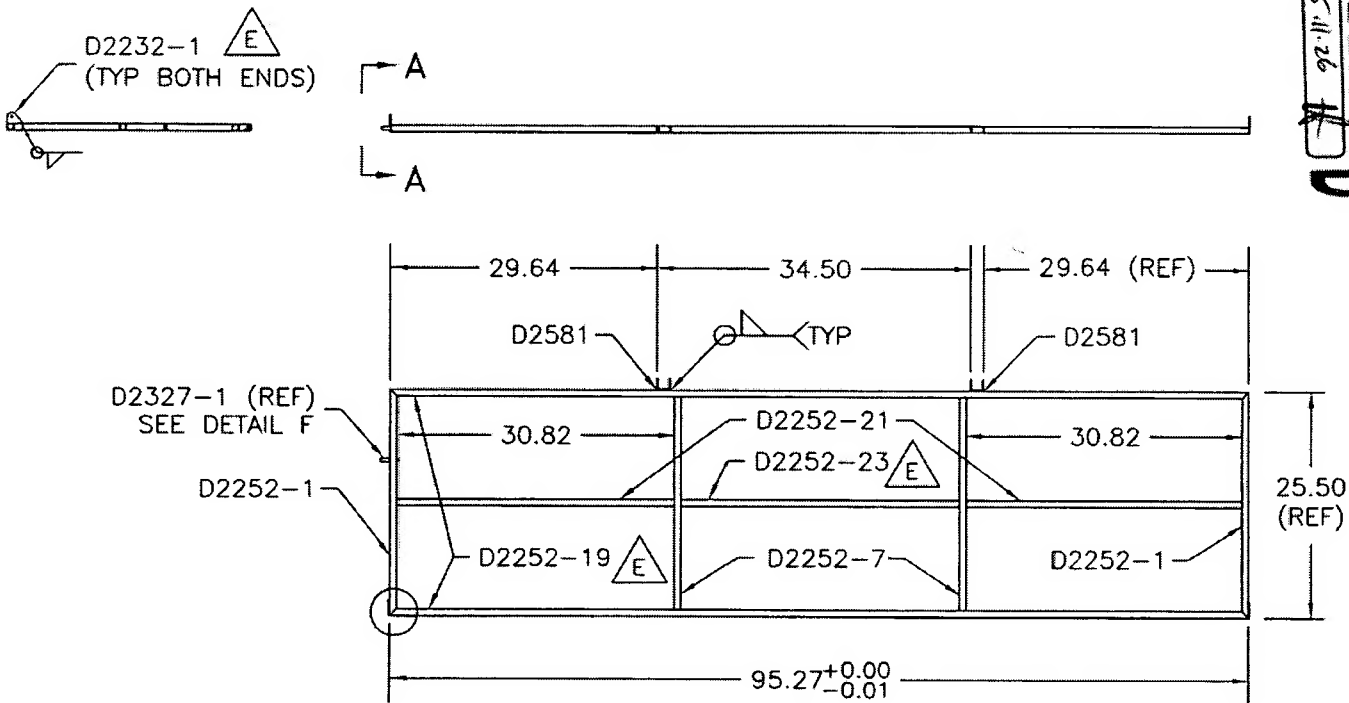
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DATE	05.11.10	TITLE	D2252	REV. E
				SHEET 2 OF 5
				SCALE
				NIS

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D2252-043 LID FRAME

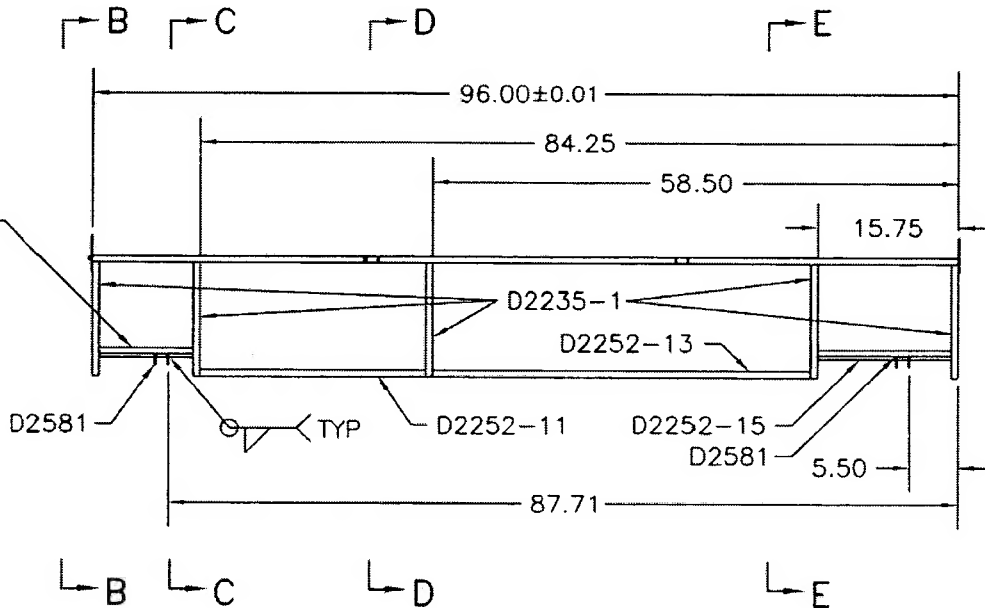
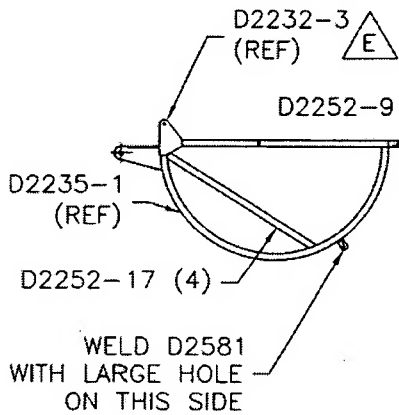
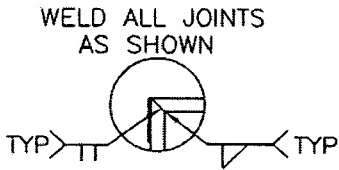
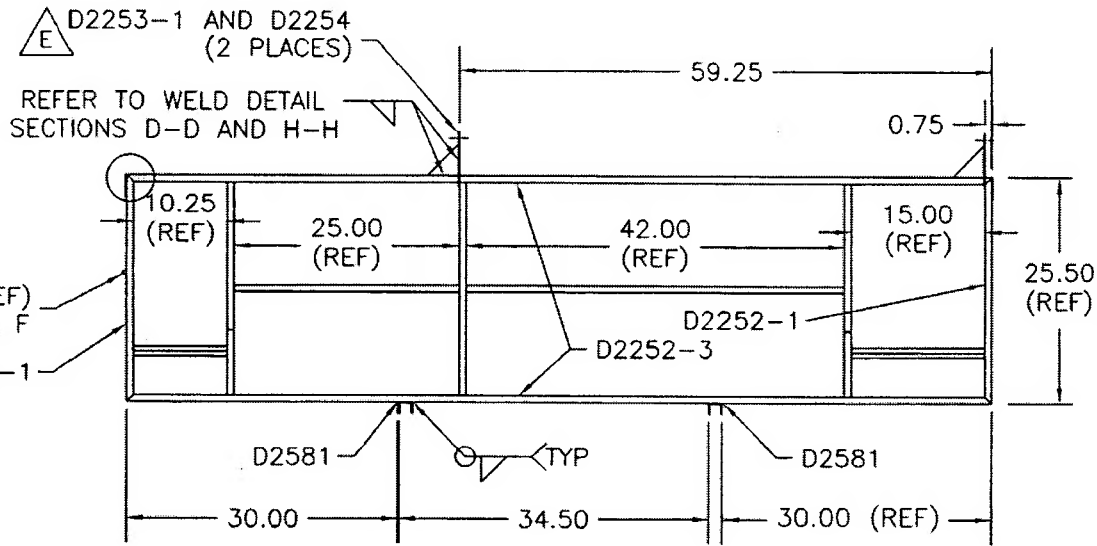


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		TITLE	BASKET ASSEMBLY (206L)	SHEET 3 OF 5
				SCALE
				NTS



D2252-041 BASKET FRAME

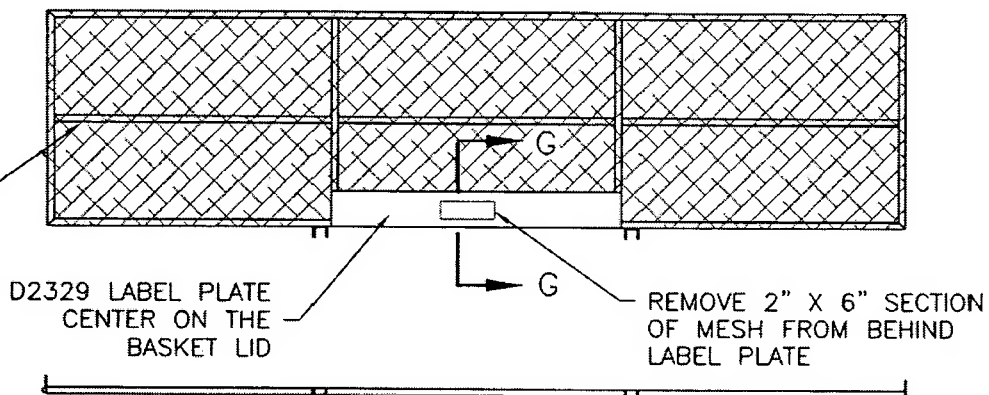
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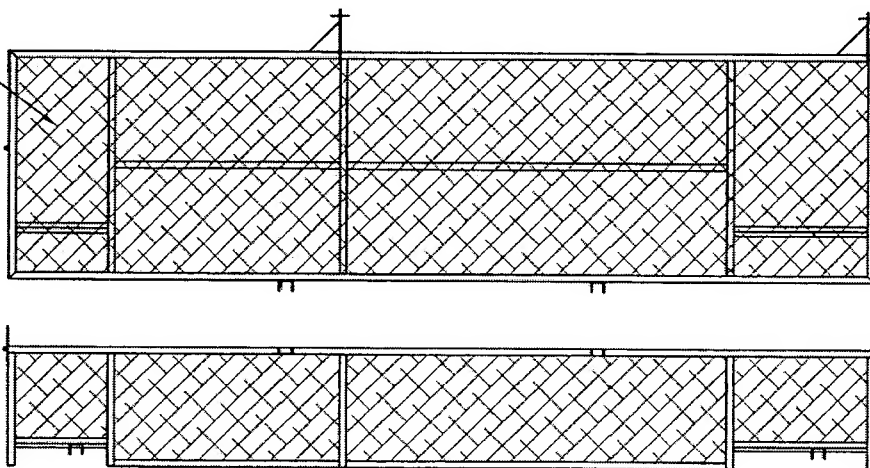
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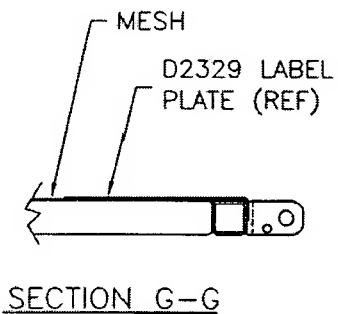
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DATE	TITLE		SCALE	
05.11.10	BASKET ASSEMBLY (206L)		NIS	



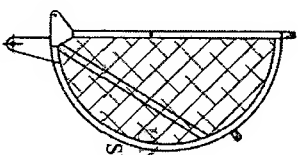
D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY



SKIN WITH 3/4-16 F
EXPANDED SS, TACK
WELD EACH STRAND
END TO FRAME

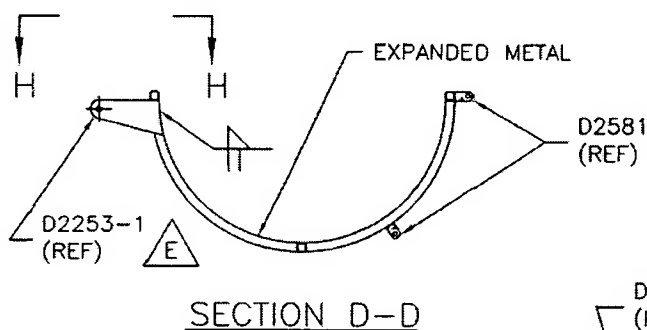
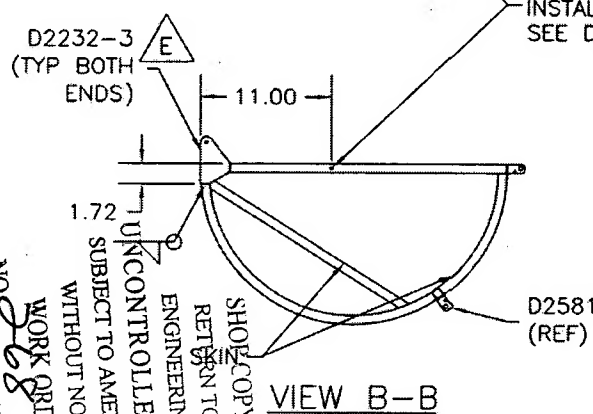
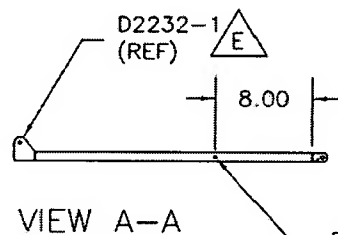
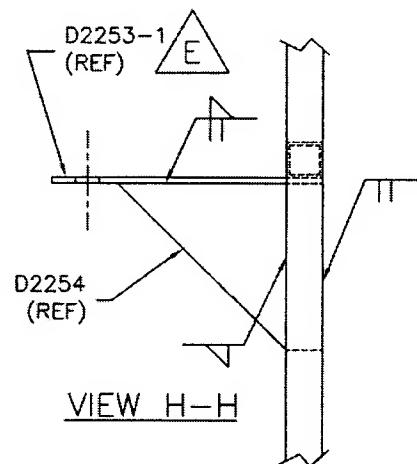
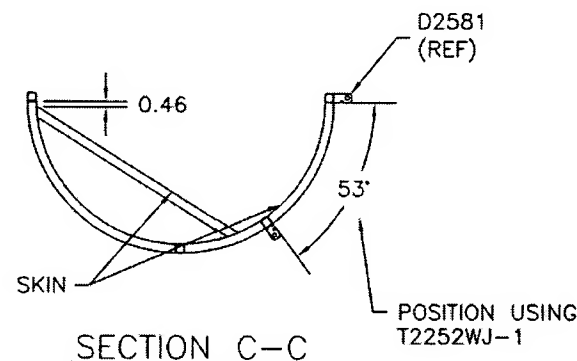
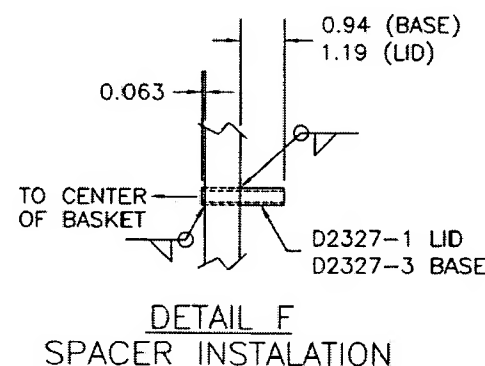
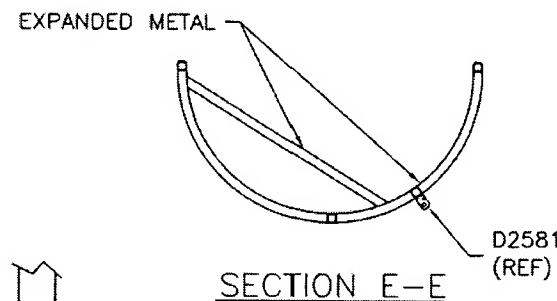


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DATE	05.11.10	DRAWING NO.	D2252	SHEET 5 OF 5
		TITLE	BASKET ASSEMBLY (206L)	SCALE
				NTS



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